

Work Order ID 128417

Friday, January 16, 2015 2:36:42 PM

128417

Page 1

Item ID: D3049-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 1/16/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/16/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MUS Date: 15-01-19 Tooling: ✓ Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1								

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3049-1_BLANK

DHMS 1"

(4) 15-01-24

120

0.00

120

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA165 and Dwg D3049Identify as D3049-1
3-Deburr4 36
15-02-02

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.00

Quality Control

4 36
15-02-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 16, 2015 2:36:42 PM

Page 1

Work Order ID: 128417

128417

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased				120	sf	14.7780	3.4	13.6			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Dec 15/01/24

Location

Loc Qty

Loc Code

MAT018

14.778

m128092

14.778

13/335

23.533

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	128417
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	.259			6" Vern	ED6
B	0.93	+/-0.030	.931			"	"
C	0.40	+0.030/-0.000	.410			"	"
D	2.00	+/-0.030	1.995			"	"
E	10.250	+/-0.010	10.250			Tape	JL8
F	4.540	+/-0.030	4.54			"	"
G	5.88	+/-0.030	5.880			"	"
H	0.38	+/-0.030	.380			Vern	ED6
I	11.50	+/-0.030	11.50			Tape	JL8
J	0.07 x 45°	+0.030/-0.010	.065			Vern	ED6
K	0.44 - 0.47	+/-0.000	.465			"	"
L	R0.25	+/-0.030	.25			"	
M	0.38	+/-0.010	.38			"	
N	0.95	+0.030/-0.010	.980			"	
O	0.69	+/-0.030	.699			"	
P	0.20	+/-0.030	.215			"	
Q	23.00	+/-0.030	23.00			Tape	JL8
R	0.25 x 45°	+/-0.030	.250			Vern	ED6

DAS

Measured by:	36
Date:	15-02-02

Audited by:	44 9-89
Date:	15/02/02

Prototype Approval:	N/A
Date:	N/A

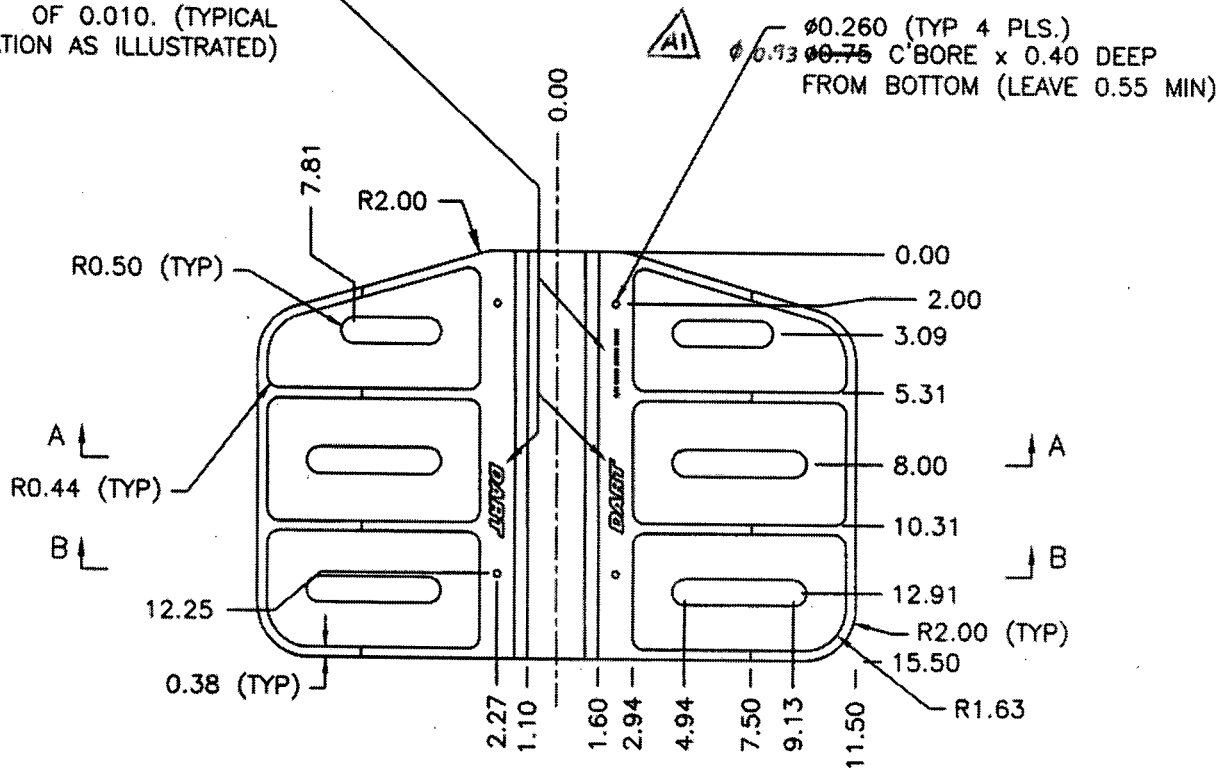
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	RF 03.01.13	$\phi 0.93$ WAS $\phi 0.75$	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHRIMP COPY
RETURN TO
DART AEROSPACE LTD
UNCONTROLLED COPY
SPEC FOR ELEMENT
MATERIAL
NO. 128417 MGS
15-01-19

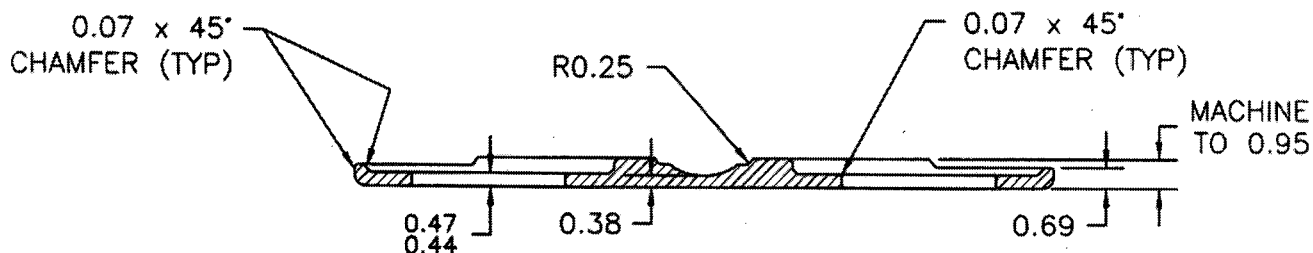
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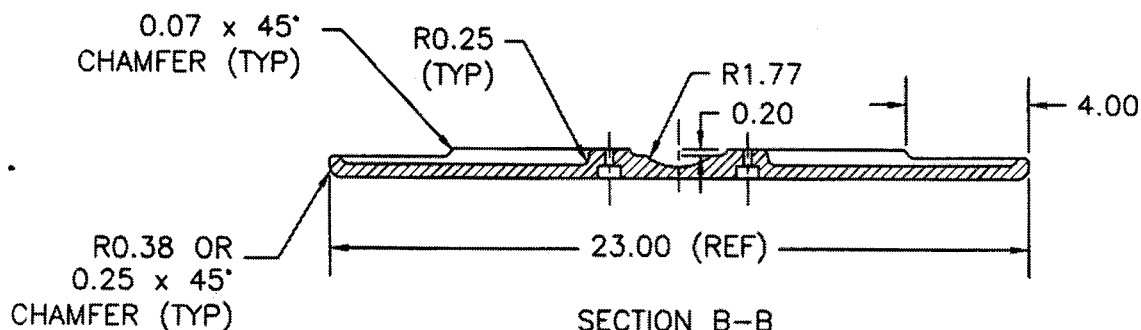


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 [Signature]



SECTION A-A



SECTION B-B

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